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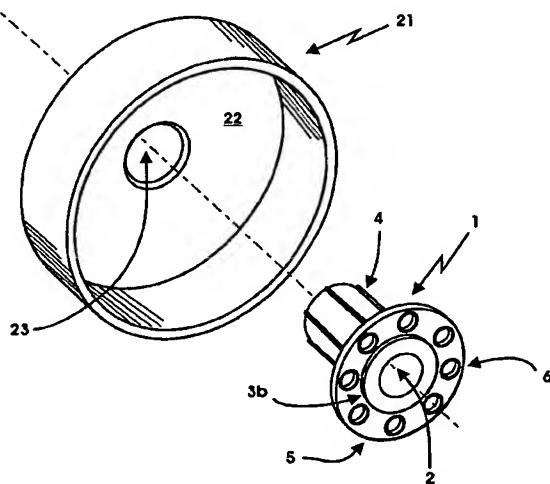
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(54) Title: CENTRIFUGAL DRUM CLUTCH ASSEMBLY AND METHOD OF MANUFACTURE



(57) Abstract: A clutch drum assembly comprising a clutch drum (21) and a drive means. The clutch drum (21) has an axis of rotation and includes an end wall (22). The drive means specifically a drive spline (1) or a fixed drive sprocket axially to one end of drive means, is a flange (5) with one or more radial evenly spaced minimally sized apertures (6) that have been counter sunk or counter bored to one side. Unitary axial motion of the two components is achieved via a mechanical connection between the two said components by tightly pressing metal from the outer surface of the end wall (22) through each of the minimally sized apertures (6) in the drive means flange (5) against a die positioned proximate to each said aperture (6) forging the metal into the counter sunk or counter bored portion of the drive means flange (5).

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